Dart Aerospace Ltd: Tuesday, 10/3/2006 3:47:38 PM Date: Kim Johnston User: **Process Sheet** Drawing Name • : LUG BRACKET Customer : CU-DAR001 Dart Helicopters Services Job Number : 28857B **Estimate Number** : 10339 : N/A : D2658 **Part Number** P.O. Number S.O. No. : NIA . D2658 REV D **Drawing Number** : 10/3/2006 This Issue : N/A Project Number Prsht Rev. MA : PURCHASED PARTS Type **Drawing Revision** First Issue : 28254B Material **Previous Run** Qty: Um: : 10/28/2006 Each **Due Date** Written By Checked & Approved By 05-11-07 Comment New Issue : Est Rev:A Est Rev:B Now on Waterjet 06-08-23 JLM **Additional Product** Job Number: . Description: Machine Or Operation: Seq. #: 1010/1025/A21/6aA SHEET M1010S12GA 1.0 0.1197 sf(s)/Unit Total: 3.5910 sf(s) ~ Comment: Qty.: 1010/1025/A21/6aA SHEET 12 GAUGE .100" THK Batch: <u>H10109</u> WATER JET FLOW WATER JET 2.0 **Comment: FLOW WATER JET** 1-Cut as per Dwg D2858 Dwg Rev: Prog Rev: 30 2-Deburr if necessary QC2 3.0 30 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK

0 BRAKE NC

NC BRAKE

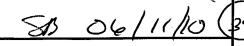
Comment: NC BRAKE

1-Deburr as required.

06:00:07

30

2-Bend on CNC brake using DT8254Identify as D2658



Dart Aerospace Ltd

W/O:		WORK ORDER	R CHANGES	3				
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #: Fault Category:		NCR: Yes No DQA: Date: 06/				06/11/13
				QA:	N/C Close	d:	_ Date: _	
WORK ORDER NON-CONFORMANCE (NCR)								

NCR:			WORK ORI	DER NON-CONFOR	RMANCE	NCE (NCR)						
DATE		Description of NC		Corrective Action			Manification.					
	STEP	Section A	Initial Chief Eng	Action Descripti Chief Eng		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

Date: User:

Tuesday, 10/3/2006 3:47:38 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 28857B

Part Number: D2658

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1

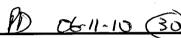




Comment: PACKAGING RESOURCE #1

Identify and Stock Location: W 5

FINAL INSPECTION/W/O RELEASE



8.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



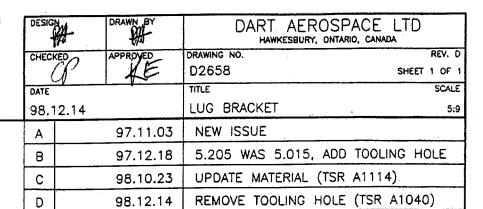
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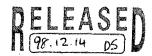
Dart Aerospace Ltd

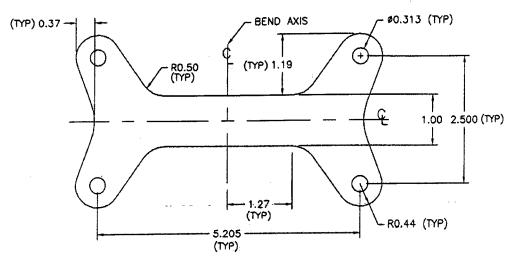
		WC	RK ORDER CH	ANGES					
STEP	PR	OCEDURE CHAI	NGE		Ву	Date Qty		Approval Chief Eng / Prod Mgr	Approval QC Inspector
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:	PAR #:	Fault Categ	jory:	N N	CR: Yes	No DQ	A :	Date: _	
·							d:	_ Date: _	
		WORK ORDE	R NON-CONFO	RMANC	E (NCR	()			
STEP	Description of NC	Corrective Action		Section B				Approval	Approval
0.121	Section A	Chief Eng	Action Descrip Chief Eng	tion	Date	Secti	on C	Chief Eng	QC Inspector
									,
	STEP	STEP PR :PAR #:	STEP PROCEDURE CHAR PAR #: Fault Category WORK ORDER STEP Description of NC Section A Initial	WORK ORDER CHANGE PROCEDURE CHANGE PAR #: Fault Category: WORK ORDER NON-CONFO STEP Description of NC	WORK ORDER CHANGES STEP PROCEDURE CHANGE PAR #: Fault Category: No WORK ORDER NON-CONFORMANCE WORK ORDER NON-CONFORMANCE STEP Description of NC	WORK ORDER CHANGES STEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes QA: N WORK ORDER NON-CONFORMANCE (NCR STEP Description of NC Section A Initial Action Description Sign &	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date :PAR #:Fault Category:NCR: Yes No DQ/QA: N/C Closed WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Section A Initial Action Description Sign & Section B Verification Action Description Sign & Section B Section A Section B Section A Section B Sectio	STEP PROCEDURE CHANGE By Date Qty :PAR #:Fault Category:NCR: Yes No DQA: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr :PAR #:Fault Category:NCR: Yes No DQA:Date:QA: N/C Closed:Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC

NOTE: Date & initial all entries

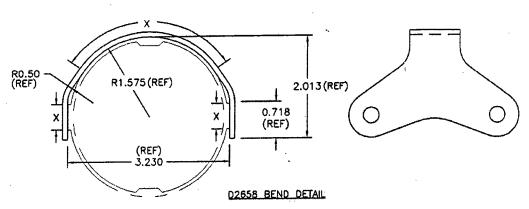








D2658 FLAT PATTERN SYMMETRICAL ABOUT BOTH CENTRE-LINES (4)



D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

SHOP COPY RETURN TO

ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)

MIN. ULTIMATE TENSILE STRENGTH = 42 ksi

MIN. YIELD TENSILE STRENGTH = 28 ksi

UNCONTROLLED MATERIAL:

UNCONTROLLED COP SUBJECT TO AMENDMENT WITHOUT NOTICE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	28857B
Description: LUG BRAXET	Part Number:	DZ658
	•	
Inspection Dwg: \\Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1,00	+ 0.036	1,009	V		Vern	
2.500	±0.010	2.448			Vern	
5,205	+0.010	5,210			Vern	
\$ 0.313	+0.006	Ø0.312			- Vern	
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Measured by:	Audited by:	7	Prototype Approval:	-
Date: 06:10:07	Date:	06-10-10	Date:	

Rev	Date	Change		Revised by	Approved
Α		New Issue	1	KJ/JLM	L



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